

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005744**Date Inspected:** 10-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Chien and Huaq Wein Pang			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006 **Component:** OBG Assembly, Tower

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Joe Alaniz was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 25% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

Bay 2

SEG1E: (vertical welds)

180, 041, 040, 081, 497, 069, 496, 068, 493, 065

035, 077, 662, 490, 034, 076, 660, 488, 032, 072

SEG1: (Horizontal weld)

024(A/B) and 033 (A/B)

Bay 14

DP540-001:

009, 011, 013, 056, 067 and 078

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP North Tower 102.5M and West Tower 95.5M Diaphragm Flange welds previously accepted by ZPMC ultrasonic technicians in accordance

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with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below.

Bay 14

DP540-001:

009, 011, 013, 056, 067 and 078

Bay 13

Cb204d-001:

003 and 007

Bay 10

NDI-A468-18M-2:

2B and 4B

NDI-A468-22M-2:

2B and 4B

Bay 11

This QA Inspector observed the following work in progress:

ZPMC welding personnel Mrs. Yang Meizhen (042195) performing groove welding of weld joint WSDI-FCSA3-2 B/C/ K-44B filler passes. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. You Qi Guo and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3C-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for

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your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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